Date: 1

Monday, 1/8/2007 10:44:20 AM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 30139A

P.O. Number

: 10731

: NIA

This Issue : 1/8/2007 : NC

Prsht Rev. : MA First Issue

: 28914A **Previous Run**

Written By

Checked & Approved By

Comment

: Est:

Type

: SMALL /MED FAB

Part Number

Drawing Name

Drawing Number

: D23243 . D2324 REV. C

: N/A

: STOP

Project Number **Drawing Revision**

:NA Material

: 1/20/2007 **Due Date**

Qty:

20 Um:

Each

J/RF

۶.O. No. : بالله:

Reformat; Incorporated D2324-3 & D2324-5 K

Additional Product

Job Number:



Sea. #:

Description: 6061-T6 Bar .75" x .75"

1.0

M6061T6B0750X00750





0.5565 f(s)/Unit Total: 11.1300 f(s)

6061-T6 Bar 0.75" x 0.75"

Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8)

(M6061T6B0.750x00.750)

Batch: M 102476

07/02/27

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Comment: Qty.:

Cut blanks: (0.75" x 0.75") x 5.75" Long Bar

3.0







Comment: HAAS CNC VERTICAL MACHINING #1

- 1- Machine as per Folio D2324-3 and Dwg D2324
- 2- Deburr and Tumble to remove sharp edges

Identify as D2324-3

07/02/28

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE



5.0

QC8

SECOND CHECK



Comment: SECOND CHECK





Dart Aerospace Ltd

W/O:		WORK ORDER CHANGE	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				

Part No:	PAR #:	_ Fault Category:	NCR: Yes No	DQA:	Date:	07/03/0
			QA: N/C CI	osed:	Date:	

NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Approval	Approval				
DATE	STEP	Section A		Initial Action Description Sign & Chief Eng Chief Eng Date		Section C	Approval Chief Eng	Approval QC Inspector				
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NOTE: Date & initial all entries

Monday, 1/8/2007 10:44:20 AM Date: User: Kim Johnston **Process Sheet Drawing Name: STOP** Customer: CU-DAR001 Dart Helicopters Services Part Number: D23243 Job Number: 30139A Job Number: Seq. #: Description: Machine Or Operation: HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 QC3 Comment: INSPECT ALODINE PACKAGING 1 PACKAGING RESOURCE #1 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock x20 Location: G4 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE 1. 640305 Job Completion

Form: rprocess

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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							'	
		٠.					'	
Part No	:	PAR #:	Fault Category:	NCR: Yes	No DQ	A :	Date:	·

QA: N/C Closed: ____ Date: ___

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Annessal	Annvoyal			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto			
		} 					·				
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30139 A
Description: Strut	Part Number:	D2324-3
Inspection Dwg: D2324 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

			,			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+/-0.010	,257	·			
Ø0.191	+/-0.010	191	<u></u>			
0.750	+/-0.010	.750	✓			
0.375	+/-0.010	175.	/			
1.875	+/-0.010	1.869	~			
5.250	+/-0.010	5.248				
5.625	+/-0.010	5.620				
-						
						·
	1					
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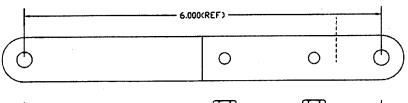
Measured by:	M8	Audited by:	And	Prototype Approval:	N/A
Date: C	25/20/18	Date:	07/02/28	Date:	N/A

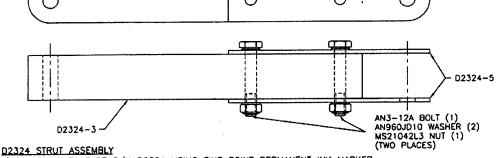
Rev	Date	Change			Revised by	Approved
Α	04.06.10	New Issue	P/O D2324-1	•	KJ/JLM , ,	-1
В	06.03.08	Dwg Rev changed			KJ/JLM 🚓	7777



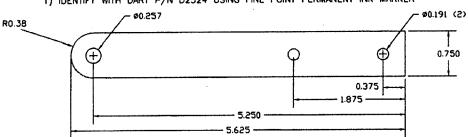
DESIGN DRAWN BY DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT, CANADA **B WILLIAMS** PH REV. C DRAWING NO. CHECKED APPROVED SHEET 1 OF 1 D2324 SCALE TITLE DATE 04,12.14 **STRUT NEW ISSUE** 94.11.08 Α B 96.05.07 UPDATE MATERIALS C 04.12.14 UPDATE NOTES

04.12.16





1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324 - 3

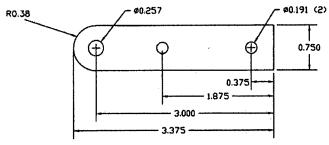
1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75

(REF DART SPEC. M6061T6B0.750X00.750)

ACID ETCH AND ALODINE PER DART QSI 005 4.1 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324 - 5

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 2) FINISH:

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER